

A

**UTILITY PATENT APPLICATION TRANSMITTAL**  
**(Large Entity)***(Only for new nonprovisional applications under 37 CFR 1.53(b))*Docket No.  
10054-2Total Pages in this Submission  
21 pages**TO THE ASSISTANT COMMISSIONER FOR PATENTS**Box Patent Application  
Washington, D.C. 20231

Transmitted herewith for filing under 35 U.S.C. 111(a) and 37 C.F.R. 1.53(b) is a new utility patent application for an invention entitled:

**HYDROALKYLATION OF AROMATIC HYDROCARBONS**

and invented by:

**C.D. Chang; J.C. Cheng; T.E. Helton; M.A. Steckel; S.A. Stevenson**If a **CONTINUATION APPLICATION**, check appropriate box and supply the requisite information:☐ Continuation ☒ Divisional ☐ Continuation-in-part (CIP) of prior application No.: 09/112,546

Which is a:

☐ Continuation ☐ Divisional ☐ Continuation-in-part (CIP) of prior application No.: \_\_\_\_\_

Which is a:

☐ Continuation ☐ Divisional ☐ Continuation-in-part (CIP) of prior application No.: \_\_\_\_\_

Enclosed are:

**Application Elements**

1. ☒ Filing fee as calculated and transmitted as described below
2. ☒ Specification having 11 pages and including the following:
  - a. ☒ Descriptive Title of the Invention
  - b. ☒ Cross References to Related Applications *(if applicable)*
  - c. ☐ Statement Regarding Federally-sponsored Research/Development *(if applicable)*
  - d. ☐ Reference to Microfiche Appendix *(if applicable)*
  - e. ☒ Background of the Invention
  - f. ☒ Brief Summary of the Invention
  - g. ☐ Brief Description of the Drawings *(if drawings filed)*
  - h. ☒ Detailed Description
  - i. ☒ Claim(s) as Classified Below
  - j. ☒ Abstract of the Disclosure

# UTILITY PATENT APPLICATION TRANSMITTAL (Large Entity)

(Only for new nonprovisional applications under 37 CFR 1.53(b))

Docket No.  
10054-2

Total Pages in this Submission  
21 pages

## Application Elements (Continued)

3. ☐ Drawing(s) (when necessary as prescribed by 35 USC 113)
- a. ☐ Formal                      Number of Sheets \_\_\_\_\_
- b. ☐ Informal                      Number of Sheets \_\_\_\_\_
4. ☒ Oath or Declaration
- a. ☐ Newly executed (original or copy)                      ☐ Unexecuted
- b. ☒ Copy from a prior application (37 CFR 1.63(d)) (for continuation/divisional application only)
- c. ☒ With Power of Attorney                      ☐ Without Power of Attorney
- d. ☐ DELETION OF INVENTOR(S)  
Signed statement attached deleting inventor(s) named in the prior application,  
see 37 C.F.R. 1.63(d)(2) and 1.33(b).
5. ☐ Incorporation By Reference (usable if Box 4b is checked)  
The entire disclosure of the prior application, from which a copy of the oath or declaration is supplied  
under Box 4b, is considered as being part of the disclosure of the accompanying application and is hereby  
incorporated by reference therein.
6. ☐ Computer Program in Microfiche (Appendix)
7. ☐ Nucleotide and/or Amino Acid Sequence Submission (if applicable, all must be included)
- a. ☐ Paper Copy
- b. ☐ Computer Readable Copy (identical to computer copy)
- c. ☐ Statement Verifying Identical Paper and Computer Readable Copy

## Accompanying Application Parts

8. ☐ Assignment Papers (cover sheet & document(s))
9. ☐ 37 CFR 3.73(B) Statement (when there is an assignee)
10. ☐ English Translation Document (if applicable)
11. ☐ Information Disclosure Statement/PTO-1449                      ☐ Copies of IDS Citations
12. ☒ Preliminary Amendment
13. ☒ Acknowledgment postcard
14. ☒ Certificate of Mailing
- ☐ First Class                      ☒ Express Mail (Specify Label No.): EE691497306US

# UTILITY PATENT APPLICATION TRANSMITTAL (Large Entity)

(Only for new nonprovisional applications under 37 CFR 1.53(b))

Docket No.  
10054-2

Total Pages in this Submission  
21 pages

## Accompanying Application Parts (Continued)

15. ☐ Certified Copy of Priority Document(s) (if foreign priority is claimed)

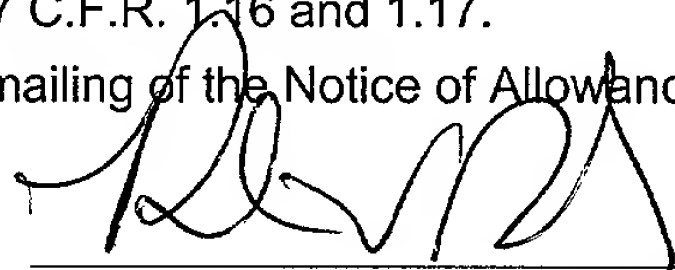
16. ☐ Additional Enclosures (please identify below):

## Fee Calculation and Transmittal

### CLAIMS AS FILED

For	#Filed	#Allowed	#Extra	Rate	Fee
Total Claims	3	- 20 =	0	x \$18.00	\$0.00
Indep. Claims	1	- 3 =	0	x \$78.00	\$0.00
Multiple Dependent Claims (check if applicable) <input type="checkbox"/>					\$0.00
BASIC FEE					\$760.00
OTHER FEE (specify purpose)					\$0.00
TOTAL FILING FEE					\$760.00

- ☐ A check in the amount of \_\_\_\_\_ to cover the filing fee is enclosed.
- ☒ The Commissioner is hereby authorized to charge and credit Deposit Account No. 19-3150 as described below. A duplicate copy of this sheet is enclosed.
- ☒ Charge the amount of \$760.00 as filing fee.
  - ☒ Credit any overpayment.
  - ☒ Charge any additional filing fees required under 37 C.F.R. 1.16 and 1.17.
  - ☐ Charge the issue fee set in 37 C.F.R. 1.18 at the mailing of the Notice of Allowance, pursuant to 37 C.F.R. 1.311(b).



Signature

Peter W. Robert  
Attorney for the Applicants  
Registration Number 31,702  
(703) 846-7732

Dated: November 9, 1999

cc:

Mobil Oil Corporation  
3225 Gallows Road  
Fairfax, VA 22037

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Application of : Clarence D. Chang et al.  
Serial No. : Not Assigned  
Filed : Concurrently Herewith  
For : HYDROALKYLATION OF AROMATIC HYDROCARBONS  
Art Unit : Not Assigned  
Examiner : Not Assigned

PRLIMINARY AMENDMENT

Fairfax, Virginia 22037

Assistant Commissioner of Patents  
Washington, D.C. 20231

Sir:

Prior to the examination of the above-identified patent application, the Examiner is respectfully requested to amend the application as follows:

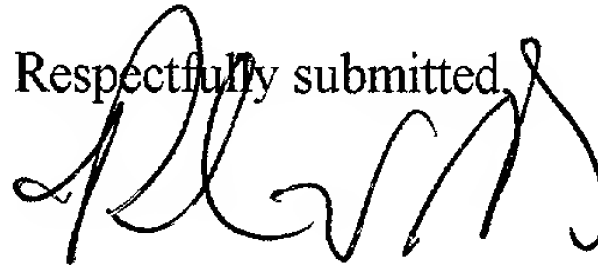
IN THE SPECIFICATION

On Page 1, amend the specification by inserting before the first line the sentence ---This is a division of copending application Serial No.: 09/112,546, filed on July 9, 1998.---

IN THE CLAIMS

Please cancel claims 1-6.

Respectfully submitted,

  
\_\_\_\_\_  
Peter W. Roberts  
Attorney for Applicant(s)  
Registration No.: 31,702  
(703) 846-7732

Mobil Oil Corporation  
3225 Gallows Road  
Fairfax, VA 22037

## HYDROALKYLATION OF AROMATIC HYDROCARBONS

### FIELD OF INVENTION

This invention relates to a catalyst and process for the hydroalkylation of aromatic hydrocarbons and particularly to a catalyst and process for the hydroalkylation of benzene to  
5 produce cyclohexylbenzene.

### BACKGROUND TO THE INVENTION

Cyclohexylbenzene can be used to produce phenol, which is one of the most important  
10 industrial chemicals in the world. As of December 1995, more than 88% of world phenol capacity was based on cumene peroxidation with acetone coproduction. One of the primary economic difficulties of the cumene peroxidation route is that it requires the existence of an available market for the co-produced acetone. Currently, the growth of market demand for phenol exceeds that for acetone, and hence there exists an acetone oversupply problem. It is  
15 expected that this unbalanced growth will continue for some time.

Hydroperoxidation of cyclohexylbenzene (analogous to cumene peroxidation) could offer an alternative route for phenol production without the problem of acetone co-production. This alternative route co-produces cyclohexanone, which is a much more valuable and desirable by-product than acetone. Thus, cyclohexanone is used partly for the manufacture of caprolactam and  
20 nylon, the same market that much phenol is intended for.

Dehydrogenation of cyclohexylbenzene also offers a low cost alternative to produce diphenyl from benzene. Diphenyl is used mainly for heat-transfer applications. Currently the main source of diphenyl is as a by-product (1 g diphenyl/100 g benzene) in benzene production by toluene dealkylation. The crude diphenyl is refined to 93-97% purity by distillation. High purity  
25 diphenyl can also be produced by direct thermal dehydrocondensation of benzene at 700-800°C in gas or electrically heated tubular reactors. This process is energy intensive and produces by-products of terphenyl, higher polyphenyls and tars.

It is known that cyclohexylbenzene can be produced from benzene by the process of hydroalkylation or reductive alkylation. In this process, benzene is heated with hydrogen in the

presence of a catalyst such that the benzene undergoes partial hydrogenation to produce cyclohexene which then alkylates the benzene starting material. Thus US Patent Nos 4,094,918 and 4,177,165 disclose hydroalkylation of aromatic hydrocarbons over catalysts which comprise nickel- and rare earth-treated zeolites and a palladium promoter. Similarly, US Patent Nos 4,122,125 and 4,206,082 disclose the use of ruthenium and nickel compounds supported on rare earth-treated zeolites as aromatic hydroalkylation catalysts. The zeolites employed in these prior art processes are zeolites X and Y. More recently, US Patent No. 5,053,571 has proposed the use of ruthenium and nickel supported on zeolite beta as an aromatic hydroalkylation catalyst. However, existing proposals for the hydroalkylation of benzene suffer from the problems that the selectivity to cyclohexylbenzene is low particularly at economically viable benzene conversion rates and that large quantities of unwanted by-products, particularly cyclohexane and methylcyclopentane, are produced.

An object of the present invention is to provide a process for the hydroalkylation of aromatic hydrocarbons with an improved selectivity for the desired cycloalkyl-substituted aromatic hydrocarbon, particularly cyclohexylbenzene, and decreased production of by-products such as cyclohexane and methylcyclopentane.

### SUMMARY OF THE INVENTION

According to one aspect of the invention there is provided a process for the hydroalkylation of an aromatic hydrocarbon comprising the step of contacting the aromatic hydrocarbon with hydrogen in the presence of a dual-functional catalyst comprising a first metal having hydrogenation activity and a crystalline inorganic oxide material having a X-ray diffraction pattern including the d-spacing maxima at  $12.4 \pm 0.25$ ,  $6.9 \pm 0.15$ ,  $3.57 \pm 0.07$  and  $3.42 \pm 0.07$  Angstrom.

Preferably, the aromatic hydrocarbon is benzene.

Preferably, the crystalline inorganic oxide material is MCM-22.

Preferably, the first metal is selected from palladium, ruthenium, nickel and cobalt.

Preferably, the catalyst also contains a second metal, different from the first metal, and selected from zinc, tin, nickel and cobalt.

In a further aspect, the invention resides in a catalyst suitable for the hydroalkylation of an aromatic hydrocarbon comprising

- (a) a first metal having hydrogenation activity and selected from palladium, ruthenium, nickel and cobalt;
- 5 (b) a second metal, different from the first metal, and selected from zinc, tin, nickel and cobalt.; and
- (c) a crystalline inorganic oxide material having a X-ray diffraction pattern including d-spacing maxima at  $12.4 \pm 0.25$ ,  $6.9 \pm 0.15$ ,  $3.57 \pm 0.07$  and  $3.42 \pm 0.07$  Angstrom.

## 10 DETAILED DESCRIPTION OF THE INVENTION

This invention relates to a catalyst and process for the hydroalkylation of aromatic hydrocarbons, particularly benzene, to cycloalkylphenyl compounds, particularly cyclohexylbenzene, using as the catalyst a hydrogenation metal-containing crystalline inorganic  
 15 oxide material having a X-ray diffraction pattern including d-spacing maxima at  $12.4 \pm 0.25$ ,  $6.9 \pm 0.15$ ,  $3.57 \pm 0.07$  and  $3.42 \pm 0.07$  Angstrom. The X-ray diffraction data used throughout this specification were obtained by standard techniques using the K-alpha doublet of copper as the incident radiation and a diffractometer equipped with a scintillation counter and associated computer as the collection system.

20 Suitable inorganic oxide materials are MCM-22 (described in U.S. Patent No. 4,954,325), PSH-3 (described in U.S. Patent No. 4,439,409), SSZ-25 (described in U.S. Patent No. 4,826,667), MCM-36 (described in U.S. Patent No. 5,250,277), MCM-49 (described in U.S. Patent No. 5,236,575) and MCM-56 (described in U.S. Patent No. 5,362,697), with MCM-22 being particularly preferred.

25 The hydrogenation metal is preferably selected from palladium, ruthenium, nickel, cobalt and mixtures thereof, with palladium and ruthenium being particularly preferred. In addition, the catalyst may contain a further hydrogenation metal, such as platinum, rhodium and rhenium, in addition to said preferred hydrogenation metals. The amount of hydrogenation metal present in the catalyst may vary significantly and will, for example, depend on the particular metal employed.  
 30 Preferably, however, the amount of hydrogenation metal present is between 0.05 and 10 wt%, and more preferably between 0.1 and 5 wt%, of the catalyst.



The catalyst preferably contains a second metal component, in addition to and different from the hydrogenation metal, which acts to promote the hydrogenation function of the catalyst. Suitable second metal components are selected from zinc, tin, nickel, cobalt and mixtures thereof. Again, the amount of second metal component present in the catalyst may vary significantly but  
 5 preferably is between 0.05 and 10 wt%, and more preferably between 0.1 and 5 wt%, of the catalyst.

The catalyst of the invention may also include a matrix or binder which is composited with the inorganic oxide material. Such matrix materials include synthetic or naturally occurring substances as well as inorganic materials such as clay, silica and/or metal oxides. The latter may  
 10 be either naturally occurring or in the form of gelatinous precipitates or gels including mixtures of silica and metal oxides. Naturally occurring clays which can be composited with the inorganic oxide material include those of the montmorillonite and kaolin families, which families include the subbentonites and the kaolins commonly known as Dixie, McNamee, Georgia and Florida clays or others in which the main mineral constituent is halloysite, kaolinite, dickite, nacrite or anauxite.  
 15 Such clays can be used in the raw state as originally mined or initially subjected to calcination, acid treatment or chemical modification.

In addition to the foregoing materials, the inorganic oxide material employed herein may be composited with a porous matrix material, such as silica, alumina, zirconia, titania, silica-alumina, silica-magnesia, silica-zirconia, silica-thoria, silica-beryllia, silica-titania as well as ternary  
 20 compositions such as silica-alumina-thoria, silica-alumina-zirconia, silica-alumina-magnesia and silica-magnesia-zirconia. The matrix can be in the form of a cogel. A mixture of these components could also be used.

The relative proportions of inorganic oxide material and binder may vary widely with the inorganic oxide material content ranging from about 1 to about 90 percent by weight and more  
 25 usually in the range of about 30 to about 80 percent by weight of the composite

The reaction conditions used in the process of the invention typically include a temperature of about 50 to 350°C, a pressure of about 100 to 7000 kPa, a benzene to hydrogen molar ratio of about 0.01 to 100 and a WHSV of about 0.01 to 100. In particular, it is important to keep the temperature as low as possible to minimize the formation of byproducts such as



methylcyclopentane and methylcyclopentylbenzene. For this reason, the temperature is preferably maintained at or below about 150°C and more preferably at or below about 120°C.

The products of the process of the invention will invariably include some dicycloalkylphenyl compounds which, where the aromatic feed is benzene, will be  
5 dicyclohexylbenzene (referred to as C<sub>18</sub> products in the Examples). Such dialkylated products can readily be separated from the effluent stream and converted to additional monoalkylated product by transalkylation with the aromatic feed, either by recycling the dialkylated product to the hydroalkylation reactor or by feeding the dialkylated product to separate transalkylation reactor. In the latter case, the transalkylation will preferably be effected in the presence of a catalyst  
10 containing the same crystalline inorganic oxide material as used in the hydroalkylation catalyst but in the absence of the metal components on the hydroalkylation catalyst and in the absence of a hydrogen co-feed.

The invention will now be more particularly described with reference to the accompanying Examples.

**Examples 1-10**

The following nine catalysts were prepared by impregnating MCM-22 extrudates (65 wt% MCM-22/35 wt% Al<sub>2</sub>O<sub>3</sub> binder) with aqueous solutions of various metal salts using incipient wetness impregnation and then drying the resultant materials:

5

	<u>Catalyst No.</u>	<u>Metal Content</u>
	1	0.3 wt% Pd
	2	0.3 wt% Ru
10	3	1.0 wt% Ni
	4	1.0 wt% Co
	5	0.6 wt% Pt
	6	0.3 wt% Rh
	7	0.6 wt% Re
15	8	0.6 wt% Pt/0.6 wt% Sn
	9	0.3 wt% Ru/0.3 wt% Sn
	10	0.3 wt% Ru/0.3 wt% Zn

A general procedure was then followed to test each metal-containing MCM-22 catalyst for benzene hydroalkylation. 2.0 g of the catalyst being tested was charged to a fixed-bed micro-reactor, where the catalyst was pretreated with 50 cc/min of flowing hydrogen for 2 hours at 300°C and 1 atm pressure. After cooling the reactor to 120°C in flowing hydrogen, benzene was fed into the reactor through a syringe pump at 60 cc/hour for 1 hr while the reactor pressure was increased to 150 psig. The benzene feed rate was then reduced to 2 WHSV and hydrogen/benzene ratio was adjusted to 1:1. Liquid products were collected in a cold product trap and analyzed off-line. The catalyst was then tested at 150°C under otherwise identical conditions. Table 1 shows data obtained at 120°C, whereas Table 2 shows data obtained at 150°C.

Table 1

Catalyst	1	2	3	4	5	6	7	8	9	10
Days on stream	1.9	1.8	1.1	0.8	1.1	0.8	0.8	0.9	9.0	3.8
Benzene Conv, %	23.8	47.9	6.7	8.8	31.9	33.7	0.7	34.1	37.7	43.1
Selectivity, wt %										
c-Hexane	18.6	53.0	49.4	11.9	97.8	98.4	-	95.6	18.7	17.2
c-Hexylbenzene	73.8	41.7	50.2	80.4	2.1	1.6	-	4.4	67.3	67.6
C <sub>18</sub> Products	7.2	4.9	0.2	7.2	0.0	0.0	-	0.0	13.6	14.7
Others	0.4	0.4	0.2	0.5	0.1	0.0	-	0.0	0.4	0.5
c-Hexylbenzene yield, wt%	17.6	20	3.4	7.1	0.7	0.5	-	1.5	25.3	29.1

5

Table 2

Catalyst	1	2	3	4	5	6	7	8
Days on stream	7.9	4.8	4.9	5.8	3.0	3.1	2.1	3.8
Benzene Conv, %	48.6	59.8	9.7	9.8	34.0	33.9	0.0	42.0
Selectivity, wt %								
c-Hexane	10.5	30.4	34.8	10.4	88.7	93.2	-	67.8
c-Hexylbenzene	70.3	58.5	60.1	78.5	10.9	6.7	-	29.5
C <sub>18</sub> Products	17.5	9.9	3.9	9.2	0.2	0.1	-	1.8
Others	1.7	1.2	1.2	1.9	0.2	0.0	-	0.9
c-Hexylbenzene yield, wt%	34.1	35	5.8	7.7	3.7	2.3	-	12.4

10 From Tables 1 and 2 it will be seen that MCM-22 catalysts with metals such as Pd, Ru, Ni, Co, Pt, Rh, Pt/Sn, Ru/Sn, and Ru/Zn were active at 120°C and 150°C for benzene hydroalkylation. Runs at 120°C provided lower dialkylation C<sub>18</sub> products, whereas the runs at 150°C provide higher benzene conversion. Among the metals utilized, Pd and Ru provided high activity for benzene conversion and high selectivity for cyclohexylbenzene. The use of second metal such as Sn improved catalyst activity and cyclohexylbenzene selectivity.

### Example 11

20 Catalyst No. 9, containing 0.3 wt% ruthenium and 0.3 wt% tin, was retested according to the general procedure described in Examples 1-10 but at a temperature of 120°C, a pressure of 110 psig and a WHSV of 1. After 22 days on stream, the benzene conversion was 43.9 wt% and the product selectivities were 12.8 wt% cyclohexane, 71.4 wt% cyclohexylbenzene, 15.2 wt% C<sub>18</sub> products and 0.6 wt% other products so that the cyclohexylbenzene yield was 31.4 wt%.

**Example 12**

5 A further catalyst, containing 0.3 wt% ruthenium and 0.3 wt% tin on MCM-56 extrudates (65 wt% MCM-56/35 wt%  $\text{Al}_2\text{O}_3$  binder), was prepared and tested according to the general procedure described in Examples 1-10 at a temperature of 120°C, a pressure of 150 psig and a WHSV of 2. After 3.8 days on stream, the benzene conversion was 51.0 wt% and the product selectivities were 45.0 wt% cyclohexane, 48.3 wt% cyclohexylbenzene, 6.1 wt%  $\text{C}_{18}$  products and 0.6 wt% other products so that the cyclohexylbenzene yield was 24.6 wt%.

10 **Example 13 (Comparative)**

15 A comparison catalyst containing 0.3 wt% ruthenium and 0.3 wt% tin on zeolite Beta extrudates (65 wt% zeolite Beta/35 wt%  $\text{Al}_2\text{O}_3$  binder), was prepared and tested according to the general procedure described in Examples 1-10 at a temperature of 120°C, a pressure of 150 psig and a WHSV of 2. After 2 days on stream, the benzene conversion was 37.7 wt% and the product selectivities were 81.3 wt% cyclohexane, 15.2 wt% cyclohexylbenzene, 2.2 wt%  $\text{C}_{18}$  products and 1.3 wt% other products so that the cyclohexylbenzene yield was only 5.7 wt%.

**Claims:**

1. A process for the hydroalkylation of an aromatic hydrocarbon comprising the step of contacting the aromatic hydrocarbon with hydrogen in the presence of a dual-functional catalyst comprising a first metal having hydrogenation activity and a crystalline inorganic oxide material having a X-ray diffraction pattern including d-spacing maxima at 12.4±0.25, 6.9±0.15, 3.57±0.07 and 3.42±0.07 Angstrom.
2. The process of claim 1 wherein the crystalline inorganic oxide material is selected from MCM-22, PSH-3, SSZ-25, MCM-36, MCM-49 and MCM-56.
3. The process of claim 1 wherein the aromatic hydrocarbon is benzene.
4. The process of claim 1 wherein the first metal is selected from palladium, ruthenium, nickel and cobalt.
5. The process of claim 1 wherein the catalyst also contains a second metal, different from the first metal, and selected from zinc, tin, nickel and cobalt.
6. The process of claim 1 wherein the contacting step is conducted at a temperature of about 50 to 350°C, a pressure of about 100 to 7000 kPa, a benzene to hydrogen molar ratio of about 0.01 to 100 and a WHSV of about 0.01 to 100.
7. A catalyst suitable for the hydroalkylation of an aromatic hydrocarbon comprising
  - (a) a first metal having hydrogenation activity and selected from palladium, ruthenium, nickel and cobalt;
  - (b) a second metal, different from the first metal, and selected from zinc, tin, nickel and cobalt.; and
  - c) a crystalline inorganic oxide material having a X-ray diffraction pattern including the following d-spacing maxima 12.4±0.25, 6.9±0.15, 3.57±0.07 and 3.42±0.07.

8. The catalyst of claim 7 wherein the crystalline inorganic oxide material is selected from MCM-22, PSH-3, SSZ-25, MCM-36, MCM-49 and MCM-56.
- 9 The catalyst of claim 7 wherein the crystalline inorganic oxide material is  
5 MCM-22.
10. A catalyst suitable for the hydroalkylation of an aromatic hydrocarbon comprising  
(a) MCM-22 zeolite;  
(b) ruthenium or palladium; and  
10 (c) tin or zinc.

Abstract

There is described a process and a catalyst for the hydroalkylation of an aromatic hydrocarbon, particularly benzene, wherein the catalyst comprises a first metal having  
5 hydrogenation activity and a crystalline inorganic oxide material having a X-ray diffraction pattern including the following d-spacing maxima  $12.4 \pm 0.25$ ,  $6.9 \pm 0.15$ ,  $3.57 \pm 0.07$  and  $3.42 \pm 0.07$ .



Docket No. 10054-1

## DECLARATION AND POWER OF ATTORNEY

I/We declare that:

1. My/Our residence, post office address(es) and citizenship(s) are as stated below next to my/our name(s).
2. I/We am/are the original, first and sole/joint inventor of the subject matter which is claimed and for which a patent is sought on the invention entitled **HYDROALKYLATION OF AROMATIC HYDROCARBONS**, the specification of which was filed as U.S. Serial No. 09/112,546 on July 9, 1998.
3. I/We have reviewed and understand the contents of the above-identified specification, including the claims.
4. I/We acknowledge the duty to disclose information which is material to the examination of this application in accordance with 37 CFR 1.56(a), including material information as defined in 37 CFR 1.56(a) which occurred between the filing date of any prior application identified in 5. below and the filing date of this application, with respect to any additional subject matter which is not disclosed in any prior application identified below.
5. I/We claim the benefit under 35 USC 120 of any United States application(s) listed below:
6. I/We appoint the following attorneys and/or agents to prosecute this application and to transact all business in the Patent and Trademark Office connected with this application:

Attorney Name	Ronald J. Cier	Registration No.	28,199
Attorney Name	Malcolm D. Keen	Registration No.	27,728
Attorney Name	Ronald A. Bleeker	Registration No.	27,773
Attorney Name	Peter W. Roberts	Registration No.	31,702

7. Address all telephone communication calls to Peter W. Roberts at telephone number (703) 846-7732.

8. Address all written correspondence to:

Ronald A. Bleeker, Esq.  
MOBIL OIL CORPORATION  
Office of Legal Counsel  
Intellectual Property  
3225 Gallows Road  
Fairfax, Virginia 22037

9. All statements made in this declaration of my/our own knowledge are true and all statements made on information and belief are believed to be true. These statements were made with the knowledge that willful false statements and the like are punishable by fine, imprisonment or both (18 USC 1001) and may jeopardize the validity of the application or any patent issuing on it.

CITIZENSHIP:

Citizen of United States of America

Clarence D. Chang  
Clarence D. Chang

RESIDENCE:

Princeton, New Jersey

Date: Sept 14, 1998

POST OFFICE ADDRESS:

11 Murray Place  
Princeton, New Jersey 08540

CITIZENSHIP:

Citizen of United States of America

Jane C. Cheng  
Jane C. Cheng

RESIDENCE:

Voorhees, New Jersey 08043

Date: 9-14-98

POST OFFICE ADDRESS:

8 Fir Lane  
Voorhees, New Jersey 08043

CITIZENSHIP:

Citizen of United States of America

Terry E. Helton  
Terry E. Helton

RESIDENCE:

Glen Mills, Pennsylvania

Date: 9-14-98

POST OFFICE ADDRESS:

503 Coventry Lane  
Glen Mills, Pennsylvania 19342

CITIZENSHIP:

Citizen of United States of America

Michael A. Steckel  
Michael A. Steckel

RESIDENCE:

Media, Pennsylvania

Date: 9-14-98

POST OFFICE ADDRESS:

153 Glen Riddle Road  
Middletown Twp  
Media, Pennsylvania 19063

CITIZENSHIP:

Citizen of United States of America

**Scott A. Stevenson**

RESIDENCE:

Houston, Texas

Date: \_\_\_\_\_

POST OFFICE ADDRESS:

**19106 Waverdale Crescent**  
**Houston, Texas 77094**

Docket No. 10054-1

## DECLARATION AND POWER OF ATTORNEY

I/We declare that:

1. My/Our residence, post office address(es) and citizenship(s) are as stated below next to my/our name(s).

2. I/We am/are the original, first and sole/joint inventor of the subject matter which is claimed and for which a patent is sought on the invention entitled **HYDROALKYLATION OF AROMATIC HYDROCARBONS**, the specification of which was filed as U.S. Serial No. 09/112,546 on July 9, 1998.

3. I/We have reviewed and understand the contents of the above-identified specification, including the claims.

4. I/We acknowledge the duty to disclose information which is material to the examination of this application in accordance with 37 CFR 1.56(a), including material information as defined in 37 CFR 1.56(a) which occurred between the filing date of any prior application identified in 5. below and the filing date of this application, with respect to any additional subject matter which is not disclosed in any prior application identified below.

5. I/We claim the benefit under 35 USC 120 of any United States application(s) listed below:

6. I/We appoint the following attorneys and/or agents to prosecute this application and to transact all business in the Patent and Trademark Office connected with this application:

Attorney Name	Ronald J. Cier	Registration No.	28,199
Attorney Name	Malcolm D. Keen	Registration No.	27,728
Attorney Name	Ronald A. Bleeker	Registration No.	27,773
Attorney Name	Peter W. Roberts	Registration No.	31,702

7. Address all telephone communication calls to Peter W. Roberts at telephone number (703) 846-7732.

8. Address all written correspondence to:

Ronald A. Bleeker, Esq.  
MOBIL OIL CORPORATION  
Office of Legal Counsel  
Intellectual Property  
3225 Gallows Road  
Fairfax, Virginia 22037

9. All statements made in this declaration of my/our own knowledge are true and all statements made on information and belief are believed to be true. These statements were made with the knowledge that willful false statements and the like are punishable by fine, imprisonment or both (18 USC 1001) and may jeopardize the validity of the application or any patent issuing on it.

CITIZENSHIP:

Citizen of United States of America

\_\_\_\_\_  
Clarence D. Chang

RESIDENCE:

Princeton, New Jersey

Date: \_\_\_\_\_

POST OFFICE ADDRESS:

11 Murray Place

Princeton, New Jersey 08540

CITIZENSHIP:

Citizen of United States of America

\_\_\_\_\_  
Jane C. Cheng

RESIDENCE:

Voorhees, New Jersey 08043

Date: \_\_\_\_\_

POST OFFICE ADDRESS:

8 Fir Lane

Voorhees, New Jersey 08043

CITIZENSHIP:

Citizen of United States of America

\_\_\_\_\_  
Terry E. Helton

RESIDENCE:

Glen Mills, Pennsylvania

Date: \_\_\_\_\_

POST OFFICE ADDRESS:

503 Coventry Lane

Glen Mills, Pennsylvania 19342

CITIZENSHIP:

Citizen of United States of America

\_\_\_\_\_  
Michael A. Steckel

RESIDENCE:

Media, Pennsylvania

Date: \_\_\_\_\_

POST OFFICE ADDRESS:

153 Glen Riddle Road

Middletown Twp

Media, Pennsylvania 19063

CITIZENSHIP:

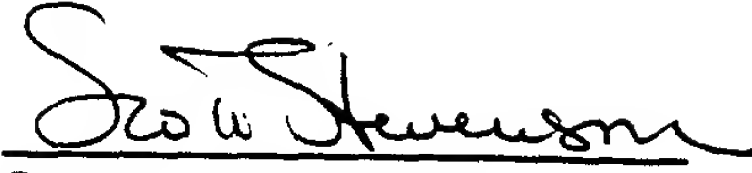
Citizen of United States of America

RESIDENCE:

Houston, Texas

POST OFFICE ADDRESS:

19106 Waverdale ~~Crescent~~ Court  
Houston, Texas 77094



Scott A. Stevenson

Date: 9/28/98